

Aero Design Ltd.**Work Order Control Sheet**Work Order#: 2017-153 Date Opened: 19 September 2017 Title: FabricationAircraft OEM: All Aircraft Model: All Product Type: Cargo Basket & Lid Product Model: Parts Quantity: See notes**Work Order Contents**

Work Order/Build Sheets (Procedures Provided)
Additional Work Sheets (Standard Practice)
Drawings (See List Below)
Parts Distribution Sheet
Sub Component Tags
Completed Certification
Time Sheet (R&D)
Notes

Initial or N/A

N/A

N/A

JC

JC

N/A

JC

N/A

N/A

Build Sheet Contents

Tasks Initialled
Dual Inspections Initialled

Initial or N/A

N/A

N/A

Drawing List

Drawing #	Rev #	Description	Initial or N/A
94011	1	Body	JC
94012	1	Lid	JC

Traveller

Cut Lid Short Rim @ 22.5" x 30
Drill hole in Lid Short Rims x 30

Cut Lid Cross Member @ 21" x 30

Cut Short Stringer @ 2.25" x 124

Initial or N/A

JF/JC

JF/JC

JF/JC

JF/JC

Component Completion

Quantity Complete on This Work Order
Quantity Incomplete on This Work Order
Further Processing Required Before Release
Release to Stock as Components

As Instructed

30/30/124

N/A

N/A

N/A

Certification

Form One Completed
Serviceable (Green) Tag Completed
In Process (Yellow) Tag Completed
Unserviceable (Red) Tag Completed
Parts Tracking (White) Tag Completed
Parts Placed in Stores for Distribution

Initial or N/A

N/A

JC

N/A

N/A

N/A

JC

Additional Documentation

Documentation of a minor change
Non-Conformance Report Required
Service Difficulty Report Required

Initial or N/A

N/A

N/A

N/A

Billing

Local (Aero Design)
Research and Development
Third Party

Initial or N/A

JC

N/A

N/A

Notes:

30 x Lid Short Rim
30 x Lid Cross Member
124 x Short Stringer

Work performed by:

Print: J. Francis / J. Clarke

ICC / Dual Inspection performed by:

Print: N/A

Work Order closed by:

Print: J. Clarke

Approved Manufacturing Facility 73-04

Sign:

Sign:

Sign:

Form 2017.03

SCA: AD02

SCA: ~~AD02~~ N/A JC

SCA: AD02

Date: 20-Sep-17

Date:

Date: 22-Sep-17

Rev. Original 23 Sep 2014



Aero Design Ltd.

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AMF 73-04

Nomenclature: LID SHORT TUBE No. of pieces: 30

Manufacturer: AERO DESIGN LTD.

Part No.: N/A 3/4" X .035 4130 TUBE Serial/Batch No.: 17055

TTSN: N/A TSO: N/A Rem.: N/A

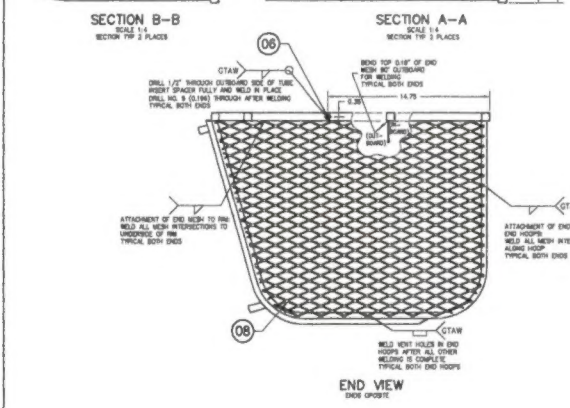
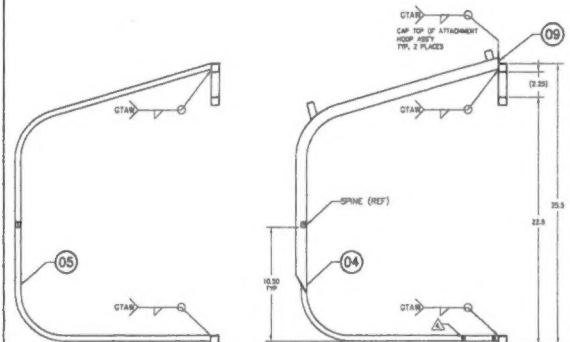
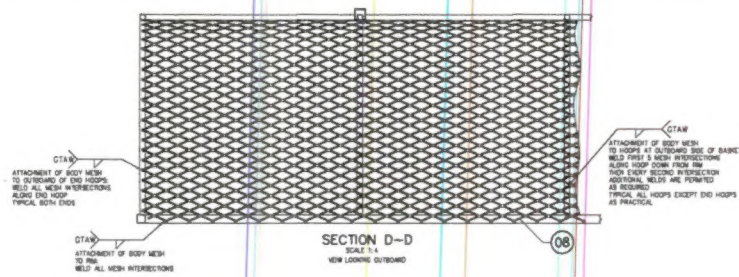
Work Order No.: 2017-133

Remaining Tasks to be Performed: NONE

Signature: JH CCL.

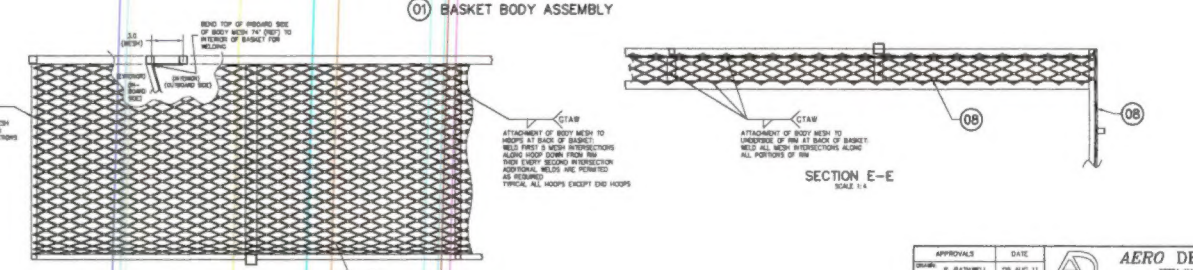
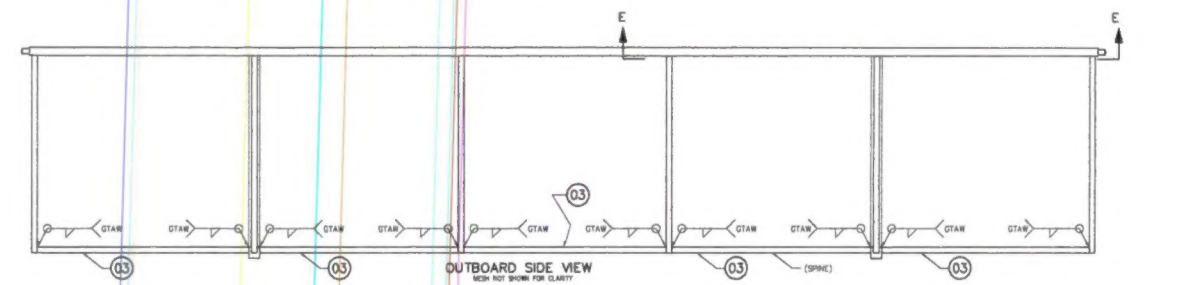
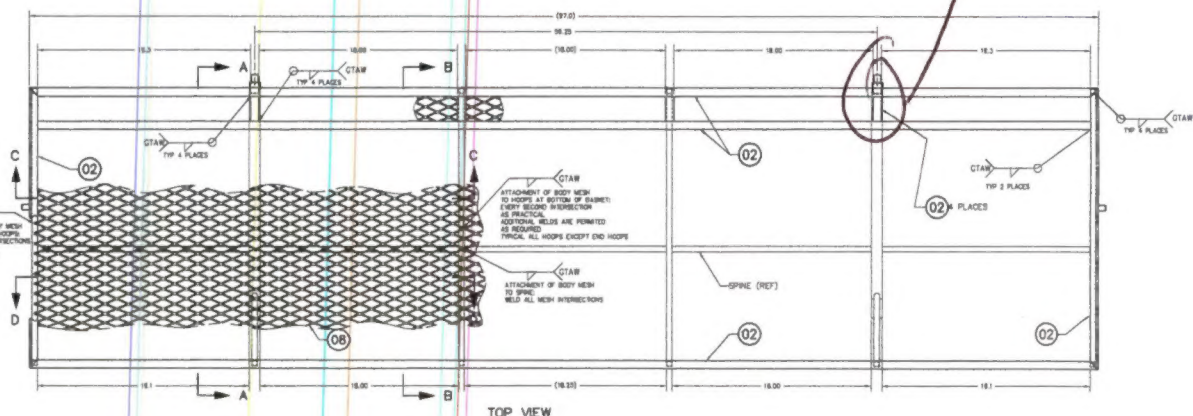
Date: 20 SEPT 2017 Lic. No. / SCA 4002

REV	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	WELD BLOCK UPDATES: WELDING ROD UPDATES: APPROPRIATE DATA ADDED		17/07/2014
2	ITEM NUMBERS UPDATED: WELDING DOWN BODY BOWCROZED		



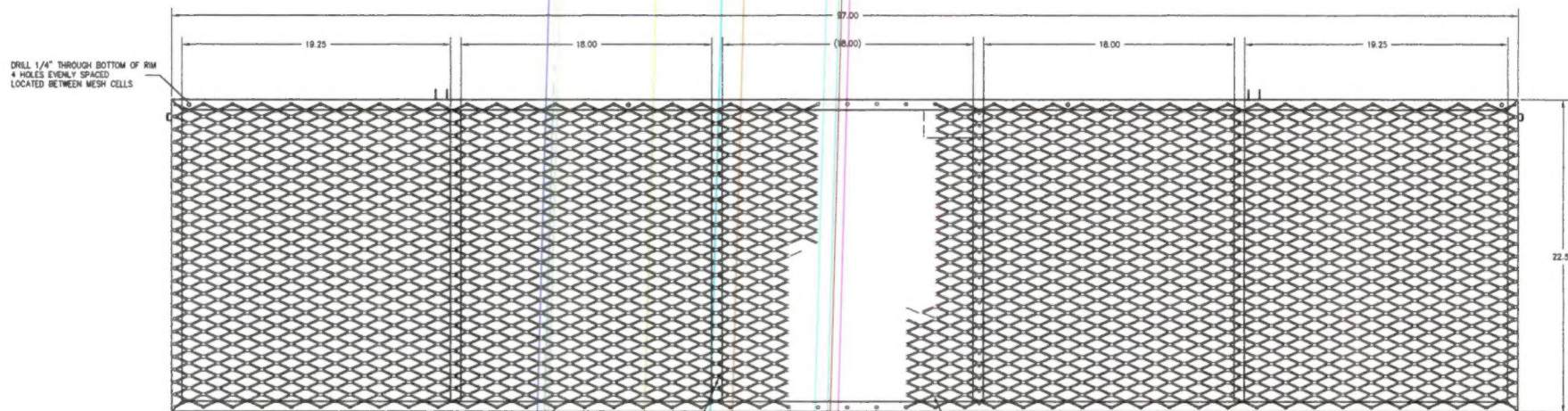
- NOTES:
1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
 2. PRIOR TO WELDING, DRILL AND (0.125) VENT HOLES IN ASSEMBLY FOR VENTING OF WELD GASES. WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
 3. WELDING OF 4130 STEEL TO BE COMPLETED BY CTAW METHOD TO AHS 5000G.
 4. 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO EXX100-2 OR EQUIVALENT. STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO EXX100 OR EQUIVALENT.
 5. INSTALL ITEM 7 (BASKET HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 8449 BEFORE WELDING HOOPS TO RAIL.
 6. FINISH THOROUGHLY CLEAN AND POWDER COAT BASKET ASSEMBLY.

QTY	PART NO.	REV	DESCRIPTION	MATERIAL NOTE	MATERIAL SPEC	STOCK SIZE
1	01		BASKET BODY ASSEMBLY			

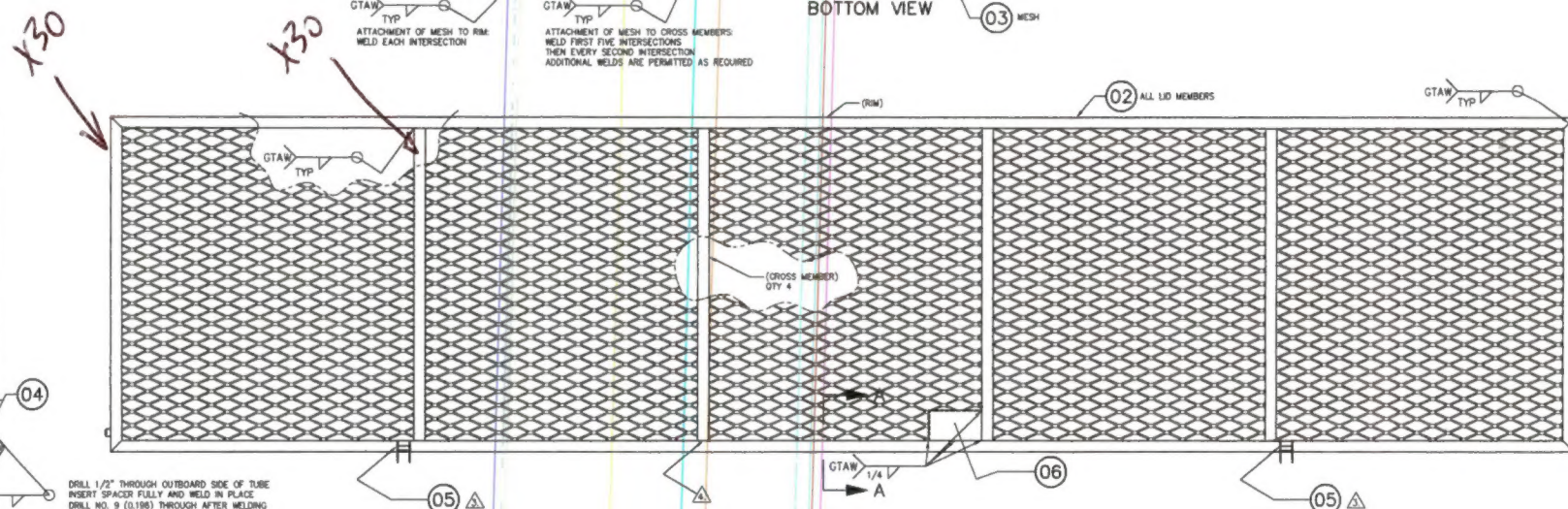


APPROVALS	DATE	AERO DESIGN LTD.
DESIGNED: E. BURTON	20 AUG 11	EUROCOPTER AS350 & AS355 SERIES
CHECKED: E. BURTON		QUICK RELEASE CARGO BASKET
		BASKET BODY ASSEMBLY (EXTRA LARGE)
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES (IN)		
DECIMALS	1/16"	
FRACTIONS	1/8"	
ANGLES	±1/2°	
SCALE: 1 OF 1		

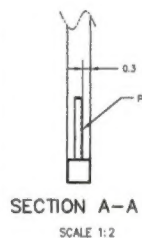
THIS DRAWING CONTAINS INFORMATION AND DATA WHICH IS PROPRIETARY TO AERO DESIGN LTD. THIS DRAWING OR ANY PORTION THEREOF, MAY NOT BE REPRODUCED, COPIED, OR DUPLICATED IN ANY MANNER, NOR USED FOR MANUFACTURING WITHOUT THE WRITTEN CONSENT OF AERO DESIGN LTD. BY ACCEPTING THIS DRAWING FOR REFERENCE, THE RECIPIENT AGREES TO HOLD AERO DESIGN LTD. HARMLESS FROM THE USE, OR MISUSE, OF THIS DRAWING OR THE INFORMATION CONTAINED THEREIN.			
REV.	DESCRIPTION OF CHANGE	INITIALS	DATE
0	INITIAL ISSUE		
1	TITLE BLOCK UPDATED: CHANGED 36273-01 TO 84263-01; ITEM #'S ADDED	BJC	10/07/2014
	WELDING ROD UPDATED: # OF WELDS DOWN BRACE TUBES INCREASED		



BOTTOM VIEW (03) MESH



TOP VIEW (01) LID ASSEMBLY



END VIEW

NOTES:

1. REMOVE ALL BURRS AND BREAK SHARP EDGES.
2. WELDING OF 4130 STEEL TO BE COMPLETED BY GTAW METHOD TO AMS 2685C.
- 4130 AND 1018 STEEL: WELDING ROD SHALL CONFORM TO ER70S-2 OR EQUIVALENT.
- STAINLESS AND 4130 STEEL: WELDING ROD SHALL CONFORM TO ER308L OR EQUIVALENT.
- INSTALL ITEM 5 (LID HANDLE PROVISIONS ASSEMBLY) IN ACCORDANCE WITH AERO DESIGN LTD. DRAWING 84263.
- DRILL #30 (0.129) HOLES IN LONG TUBE MEMBERS AT BRACE LOCATIONS TO VENT WELD GASSES.
- WHEN ASSEMBLY IS COMPLETE, FILL ALL EXPOSED VENT HOLES WITH ROSETTE WELD.
5. FINISH: THOROUGHLY CLEAN AND POWDER COAT LID ASSEMBLY.

PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	36204-10	06 PLACARD BRACKET			
2	84263-01	05 LID HANDLE PROVISIONS ASSEMBLY			
3	49216-01	04 SPACER			
4	5/4 - 16F	03 MESH	MILD STEEL	COMMERCIAL	
5	94012-01	01 LID ASSEMBLY	4130 STEEL COND. N	MIL-T-8736	0.75 X 0.035 SOR TUBE

APPROVALS	DATE	AERO DESIGN LTD.	
DRAWN: R. RATHWELL	05 AUG 11		
CHECKED: E. BURGOIN		8086A MALASPINA ROAD POWELL RIVER, BC, CANADA, V8A 0G3 TEL: 604.485.2378 www.aerodesign.ca	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES. TOLERANCES ON:		EUROCOPTER AS350 & AS355 SERIES QUICK RELEASE CARGO BASKET LID ASSEMBLY (EXTRA LARGE)	
DECIMALS	ANGLES	SCALE 1 : 4	
X.XX ±0.010	±1/2°	DWG. SIZE	DWG. NO.
X.XX ±0.03		SHEET 1 OF 1	REV.
X.X ±0.1		A1	94012 1



Type:

Work Order:

[illegible]

Work Order: 2017-153Date Opened: 19 SEPT 2017Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Lid Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>N/A</u>	94012	94012-01	Lid Assembly		
Step 1				Rim Assembly		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>N/A</u>
→	. 2	<u>x30</u>	--	3/4" Tube - Short Rim (22.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
Step 2				Weld Rim Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>N/A</u>
Step 3				Inspection - Rim	None	
Step 4				Frame Assembly		
→	. 4	<u>x30</u>	--	3/4" Tube - Cross Member (21")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
Step 5		70405		Option: Frame Assembly - with walkway		
	. 10		--	1/2" Tube - walkway	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>N/A</u>
Step 6				Weld Frame Assembly		
	. A/R			Welding Rod	ER70S-2 TIG Rod	<u>N/A</u>
Step 7				Inspection - Frame Assembly	None	
Step 8				Mesh Assembly		
	. 1		--	Mesh (lid - 96" x 22")	3/4-16F Expanded Mild Steel sheet	<u>N/A</u>
Step 9				Weld Mesh		
	. A/R			Welding Rod	ER70S-6 MIG Wire	<u>N/A</u>

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Eurocopter AS350 / AS355
Extra Large Lid Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 10				<i>Weld Lid Components</i>		
	. 1	84262	84262-01	Upper Handle Bracket Assembly		N/A
	. . 4		36273-01	Lid Bracket	321 Stainless, 0.050 Sheet	N/A
	. . 2		36275-02	Support	304 Stainless, 5/16" Rod	N/A
	. A/R			Welding Rod	ER308L TIG Rod	N/A
	. 2		49216-01	Spacer (Lid prop)	304 Stainless, 1/2" Dia.	N/A
	. A/R			Welding Rod	ER308L TIG Rod	N/A
	. 1		36204-10	Placard Bracket	1018 Steel, 0.035" Sheet	N/A
	. A/R			Welding Rod	ER70S-2 TIG Rod	N/A
Step 11				<i>Clean Up</i>		
Step 12				<i>Inspection - Final Assembly</i>		
Step 13				Powder Coating		N/A

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Material Tracking Sheet
Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

1 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
	<u>N/A</u>	94011	94011-01	Basket Assembly		
Step 1				<i>Rim Assembly</i>		
	. 2		--	3/4" Tube - Long Rim (97")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>N/A</u>
	. 2		--	3/4" Tube - Short Rim (25.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>N/A</u>
	. 1		--	3/4" Tube - Long Stringer (95.5")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>N/A</u>
	<u>→</u> . 4	<u>X124</u>	--	3/4" Tube - Short Stringer (2.25")	4130 Steel, 3/4" x 0.035 Sqr. Tube	<u>17055</u>
Step 2				<i>Weld Rim Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>N/A</u>
Step 3				<i>Inspection - Rim</i>	<i>None</i>	
Step 4				<i>Frame Assembly</i>		
	. 4		94030-01	Hoop - standard	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>N/A</u>
	. 2		94023-01	Hoop - attachment		<u>N/A</u>
	. 5		--	1/2" Tube - spine	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>N/A</u>
Step 4.g.		70406	70406-01	<i>Option: Front End Cutout</i>		
			70406-03	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>N/A</u>
			70406-04	1/2" Tube	4130 Steel, 1/2" x 0.035 Sqr. Tube	<u>N/A</u>
Step 5				<i>Weld Frame Assembly</i>		
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	<u>N/A</u>
Step 6				<i>Inspection - Frame Assembly</i>	<i>None</i>	
Step 7				<i>Mesh Assembly</i>		
	. 1		--	Mesh (Body - 56" x 96")	3/4-16F Expanded Mild Steel sheet	<u>N/A</u>
	. 2		--	Mesh (End - 25" x 18")	3/4-16F Expanded Mild Steel sheet	<u>N/A</u>

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Eurocopter AS350 / AS355
Extra Large Basket Body Fabrication

2 of 2

Ass'y Step	Qty	Detail Drawing	Part Number	Description	Material	PO/WO
Step 8				<i>Weld Mesh</i>		
	. A/R		--	Welding Rod	ER70S-6 MIG Wire	N/A
Step 9				<i>Weld Basket Components</i>		
	. 2		49215-01	Spacer (Lid prop)	304 Stainless Steel, ½" Dia.	N/A
	. A/R		--	Welding Rod	ER308L TIG Rod	N/A
Step 9.b.	. 1		--	Cap	1018 Mild Steel, 0.032" Sheet	N/A
	. A/R		--	Welding Rod	ER70S-2 TIG Rod	N/A
Step 10				<i>Clean Up</i>	None	
Step 11				<i>Inspection - Final Assembly</i>	None	
Step 12				Powder Coating		N/A